

Work Order ID 51823

September 4, 2009 8:40:48 AM



Page 1

Item ID: D3847-1

Accept

Setup Start

Revision ID: B

Stop

Item Name: WEARPAD

Start Date: 09/04/2009 Start Qty: 30.00

Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-09-04 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3847

B

100

0.00



Waterjet

FLOW CNC Waterjet

SC4
.063

Memo

1-Cut as per Dwg D3847

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.00

B 9-9-01

35

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

Quality Control

0.00

B 9-9-01

W/O:		WORK ORDER CHANGES					
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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

2) S 09/09/23

0.00

Memo

count
35

130



Brake NC

Brake NC

Memo

Form as per dwg

0.00

0.00

8B 09/09/24

35

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

2) S 09/09/24

0.00

Memo

count
35

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Large Fab

Memo

Weld hardcoat as per dwg
A/R 2059B Batch: 11091893

11/25/09

0.00

SP 09.09.28

35x

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

=> S 02/09/30

center
x35



170

0.00



QC

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

=> S 02/09/30

center
x35



Quality Control

2410
11/09/09

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

180



Powdercoat

Powder Coating

Operation
Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

M109091
START: 1:45pm
Temp: 320°F
FIN: 2:15pm

Set Up/
Run Hours

0.00

0.00

Draw
Number

09/10/01

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

35x

190



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BL 09-10-2

35

200



Packaging

Packaging

Identify as per dwg & Stock Location EP-17

Memo

0.00

0.00

ul 09/10/02

35x

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/09 *[Signature]*
PL 09-10-2

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

September 4, 2009 8:40:48 AM

Page 1

Work Order ID: 51823



Parent Item: D3847-1RevB



Parent Item Name: WEARPAD

Start Date: 09/04/2009

Required Date: 09/11/2009

Comments:

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

261.2310

3.9032



189-9-21

304/316 Sheet .063

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

261.2309737

106860

16.018

111924

33.0549737

112290

36.8947

112442

79.2633

112567

96

111924

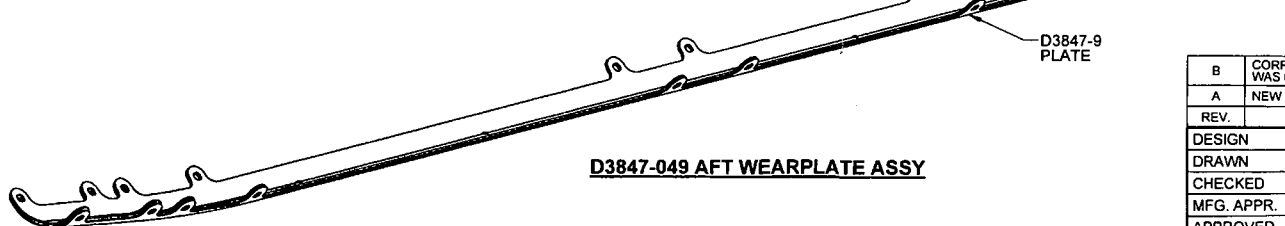
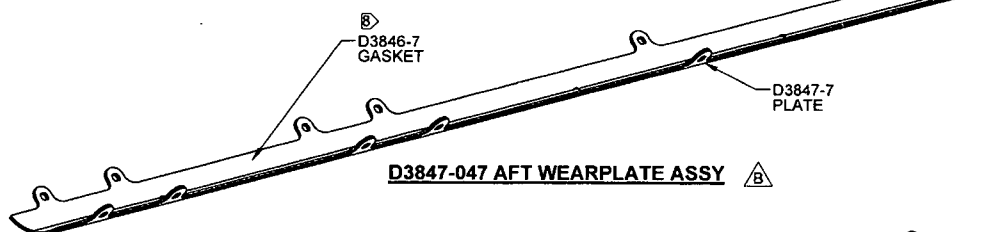
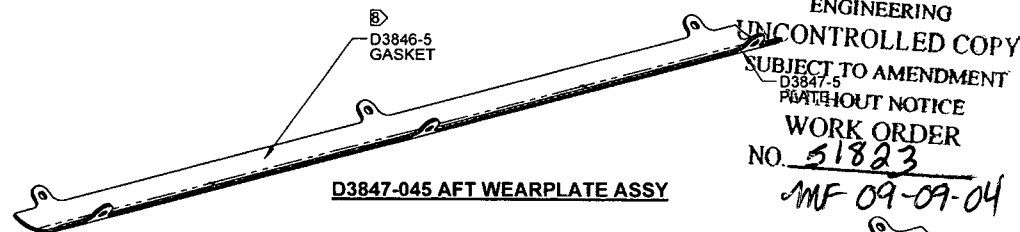
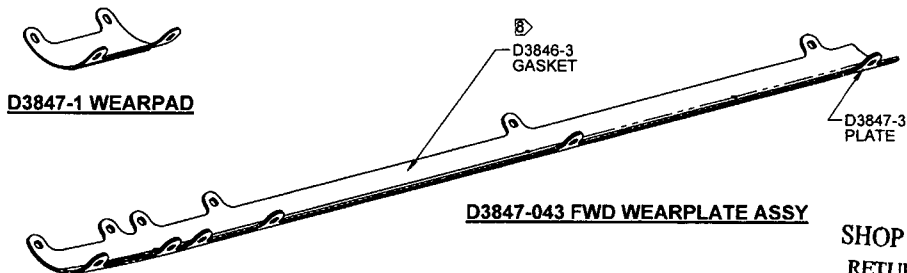
W/O:		WORK ORDER CHANGES					
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ITEM	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
1	X				D3847-043	FWD WEARPLATE ASSY, STD/FLOAT GEAR
2		X			D3847-045	CENTER WEARPLATE ASSY, STD/FLOAT GEAR
3			X		D3847-047	AFT WEARPLATE ASSY, STD GEAR
4				X	D3847-049	AFT WEARPLATE ASSY, FLOAT GEAR
11	1				D3847-3	PLATE
12		1			D3847-5	PLATE
13			1		D3847-7	PLATE
14				1	D3847-9	PLATE
15	1				D3846-3	GASKET
16		1			D3846-5	GASKET
17			1		D3846-7	GASKET
18				1	D3846-9	GASKET
31	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-XXX" USING YELLOW PAINT MARKER AT INSIDE SURFACE
 - 7) WEIGHT: D3847-043 = 1.71 lbs
D3847-045 = 1.49 lbs
D3847-047 = 2.00 lbs
D3847-049 = 4.21 lbs
 - 8) BOND D3846-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE



D3847-11 WEARPAD

RELEASED
09/07/15

B	CORRECT TYPO D3847-047 WAS D3847-045, ZN B5-1; 5.82 WAS 6.25 (ZN A4-2); 45.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3847	SHEET 1 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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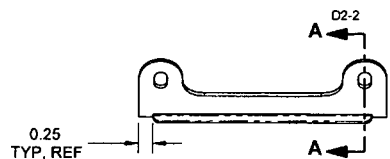
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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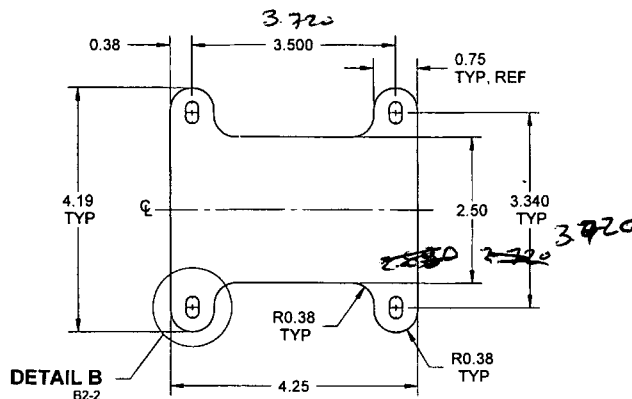
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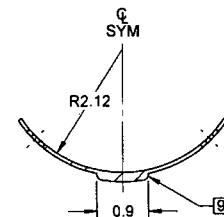
8 7 6 5 4 3 2 1



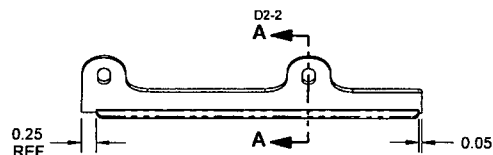
D3847-1 WEARPAD
MADE FROM D3847-1F FLAT PATTERN



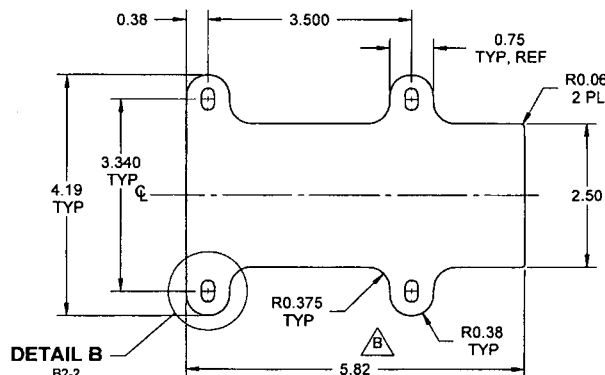
D3847-1F FLAT PATTERN



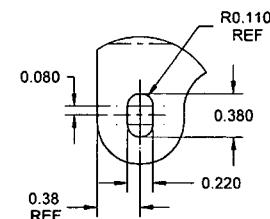
SECTION A-A D7-2 B7-2



D3847-11 WEARPAD
MADE FROM D3847-11F FLAT PATTERN



D3847-11F FLAT PATTERN



DETAIL B C5-2 B5-2
TYP, SCALE 2X

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK), (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3847-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
D3847-1 = 0.03 lbs
D3847-11 = 0.47 lbs
- 8) WELD PER QSI 004
- 9) APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.19 TO 0.25 THICK UNLESS OTHERWISE INDICATED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D3847	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.	<i>RF</i>	WEARPLATE ASSY	NTS
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RELEASED
12/17/15

8 7 6 5 4 3 2 1

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